POWERMATIC®

WMH TOOL GROUP

Operating Instructions and Parts Manual

8-inch Jointer

Model 60B

WMH TOOL GROUP

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Elgin, Illinois 60124
Ph.: 800-274-6848
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Part No. M-0460282
Revision G 12/06

Warranty and Service

WMH Tool Group, Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these WMH Tool Group Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your POWERMATIC® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION

WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit powermatic.com.

WARRANTY

POWERMATIC products carry a limited warranty which varies in duration based upon the product.

Warranty reverts to 1 Year if above products are used for commercial, industrial or educational purposes

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?

The general POWERMATIC warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?

The Five Year Warranty does not cover products used for commercial, industrial or educational purposes. Products with a Five Year Warranty that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option.

We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the handling and shipping costs of the return.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY

WMH TOOL GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WMH TOOL GROUP SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

WMH Tool Group sells through distributors only. The specifications in WMH catalogs are given as general information and are not binding. Members of WMH Tool Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

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Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation. Know the limitations and hazards in using the jointer. Decals are placed on each machine as reminders of good safety practice.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This jointer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a jointer, do not use until proper training and knowledge have been obtained.
5. Do not use this jointer for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Use extra care in the location of the jointer in the shop. Place the machine so that potential kickback area is not in line with aisles, doorway, wash stations, or other work areas.
7. Always wear approved safety glasses/face shields while using this jointer. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
8. Before operating this jointer, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
9. Wear ear protectors (plugs or muffs) during extended periods of operation.
10. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

    - Lead from lead based paint.
    - Crystalline silica from bricks, cement and other masonry products.
    - Arsenic and chromium from chemically treated lumber.

    Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
11. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
12. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
13. Make certain the machine is properly grounded.
14. Make all machine adjustments or maintenance with the machine unplugged from the power source. A machine under repair should be RED TAGGED to show that it should not be used until maintenance is complete.
15. Remove loose items and unnecessary work pieces from the area before starting the machine. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
16. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately upon completion of maintenance.
17. Make sure the jointer is firmly secured to the floor or bench before use.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.

Warnings

20. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
21. Keep visitors a safe distance from the work area. **Keep children away.**
22. Make your workshop child proof with padlocks, master switches or by removing starter keys.
23. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
24. Maintain a balanced stance at all times so that you do not fall or lean against the knives or other moving parts. Do not overreach or use excessive force to perform any machine operation.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep knives sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Turn off the machine and disconnect from power before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
28. Do not stand on the machine. Serious injury could occur if the machine tips over.
29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. When working a piece of wood on the jointer, follow the 3-inch radius rule: The hands must never be closer than 3 inches to the cutterhead. See Figure 1.
31. Always use a hold-down or push block when surfacing stock less than 12 inches long, or 3 inches wide, or 3 inches thick.

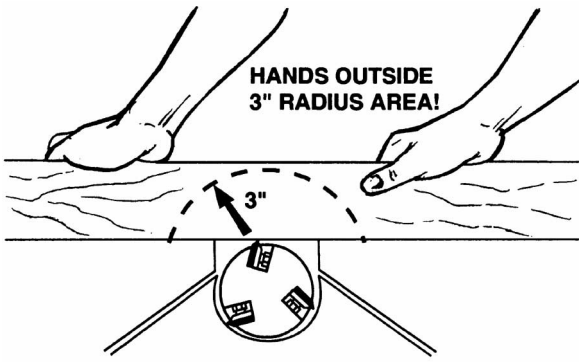


Figure 1

32. Do not perform jointing operations on material shorter than 8 inches in length, narrower than 3/4 inches, or less than 1/4 inch thick.
33. Do not make cuts deeper than 1/8 inch to avoid overloading the machine and to minimize chance of kickback.
34. Never apply pressure to stock directly over the cutterhead. This may result in the stock tipping into the cutterhead along with the operator's fingers. Position hands away from extreme ends of stock, and push through with a smooth, even motion. Never back workpiece toward the infeed table.
35. "Pull-out" and the danger of kicked back stock can occur when the work piece has knots, holes, or foreign materials such as nails. It can also occur when the stock is fed against the grain on the jointer. The grain must run in the same direction you are cutting. Before attempting to joint or plane, each work piece must be carefully examined for stock condition and grain orientation.

    NOTE: At certain times it may be necessary to plane against the grain when working with a swirl grain wood or burl. With this type of work the operator must use a lesser depth of cut and a slow rate of feed.

Familiarize yourself with the following safety notices used in this manual:

⚠CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

Familiarize yourself with the location and content of these decals:

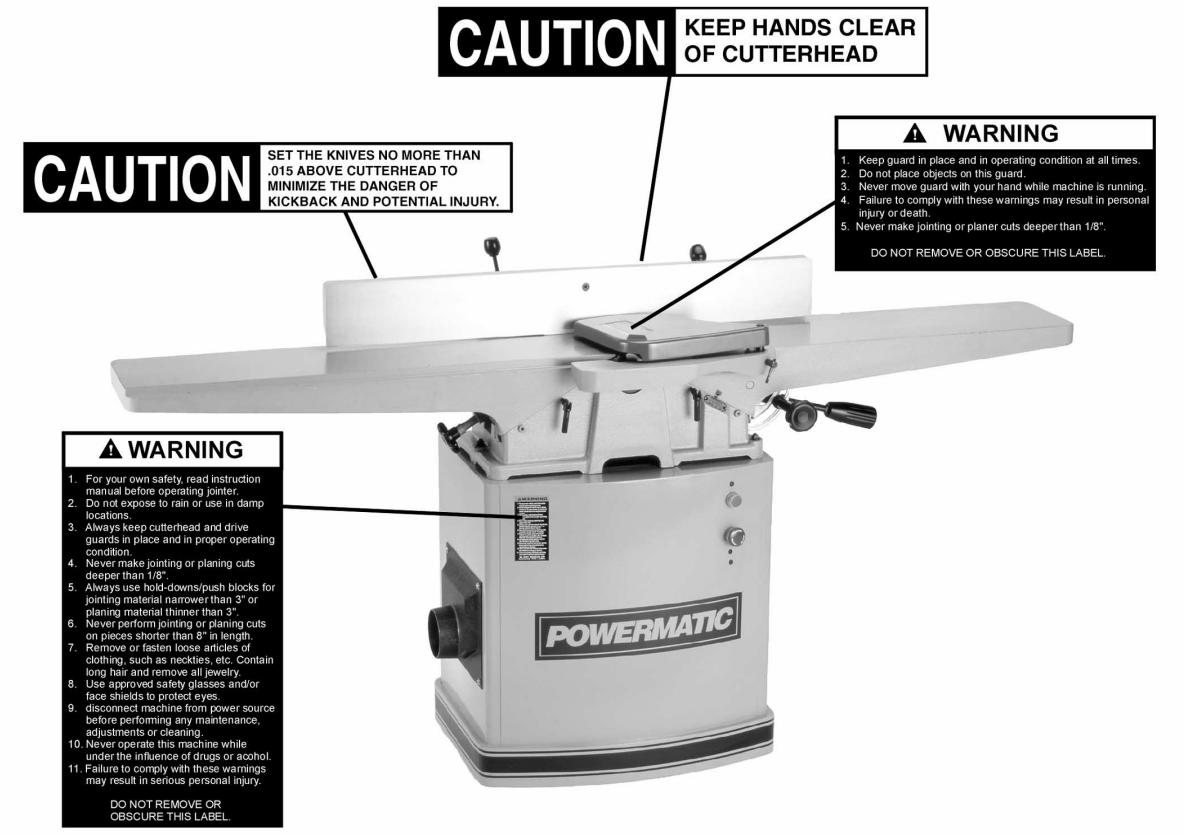


Figure 2

Specifications

Model Number	60B	60B
Stock Number	1610077K	1610078K
Table (in.)	8-1/2 W x 72 L	8-1/2 W x 72 L
Cutting arc (in.)	3	3
Knives, high speed steel	three @ 1/8" x 11/16" x 8-1/16"	three @ 1/8" x 11/16" x 8-1/16"
Knife adjustment	springs or jack screws	springs or jack screws
Maximum speed of cutterhead (RPM)	7,000	7,000
Knife cuts per minute	21,000	21,000
Maximum depth of cut (in.)	1/2	1/2
Maximum rabbeting cut (in.)	1/2 x 8	1/2 x 8
Fence size overall (in.)	4-3/4 x 38-1/4	4-3/4 x 38-1/4
Height, floor to outfeed table (in.)	32	32
Overall height, without stand (in.)	14-1/4	14-1/4
Overall height, with stand (in.)	38	38
Footprint (in.)	24 x 17-1/2	24 x 17-1/2
Motor	2 HP, 1Ph, 230V	3HP, 3Ph, 230/460V (pre-wired 230V)
Approx. Net Weight (Jointer Base) (lbs.)	280	280
Approx. Net Weight (Stand) (lbs.)	113	116

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WMH Tool Group reserves the right to change specifications at any time and without prior notice, without incurring obligations.

Features of the 60B Jointer

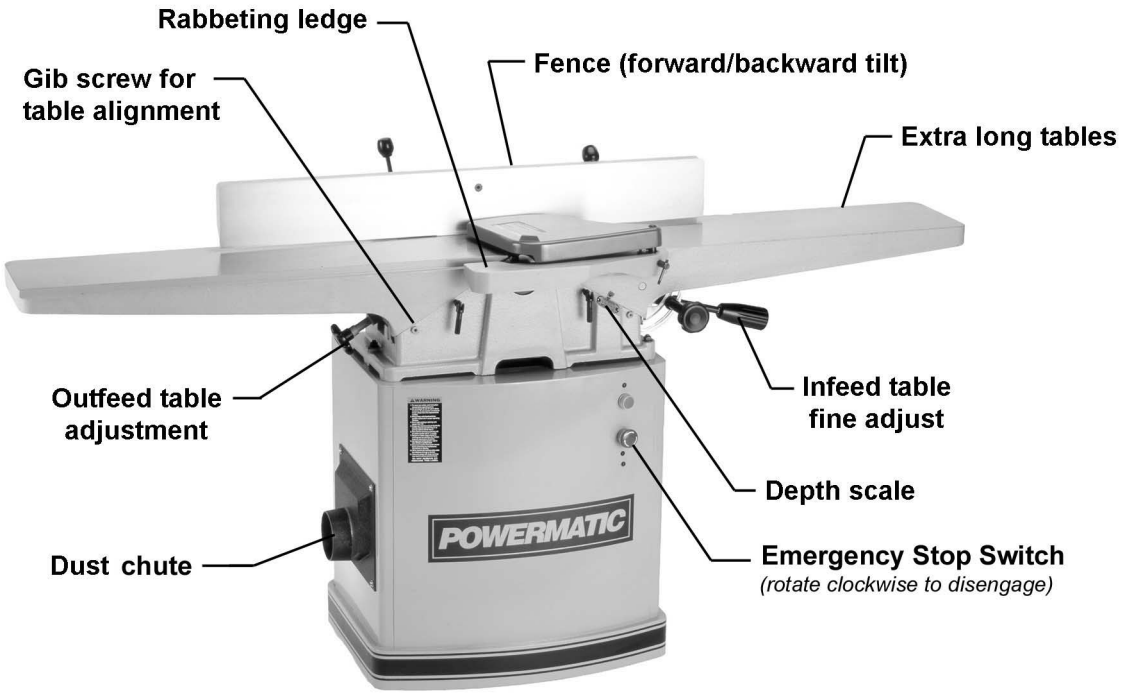


Figure 3

Receiving

Open both shipping crates and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Before operating your jointer, read this instruction manual thoroughly for assembly, maintenance and safety instructions.

Crate #1 contents

1 jointer stand with motor
1 door
1 dust chute

Crate #2 contents

1 table and fence assembly
1 drive belt
1 belt guard
1 cutterhead guard
2 push pads
1 hardware bag
1 knife setting gauge
1 manual
1 warranty card

The contents of the hardware bag are shown in Figure 4.

NOTE: Exposed metal surfaces such as the table and fence have been given a protective coating at the factory. This should be removed with a soft cloth and solvent (such as mineral spirits) once the machine has been assembled. Do not use an abrasive pad.

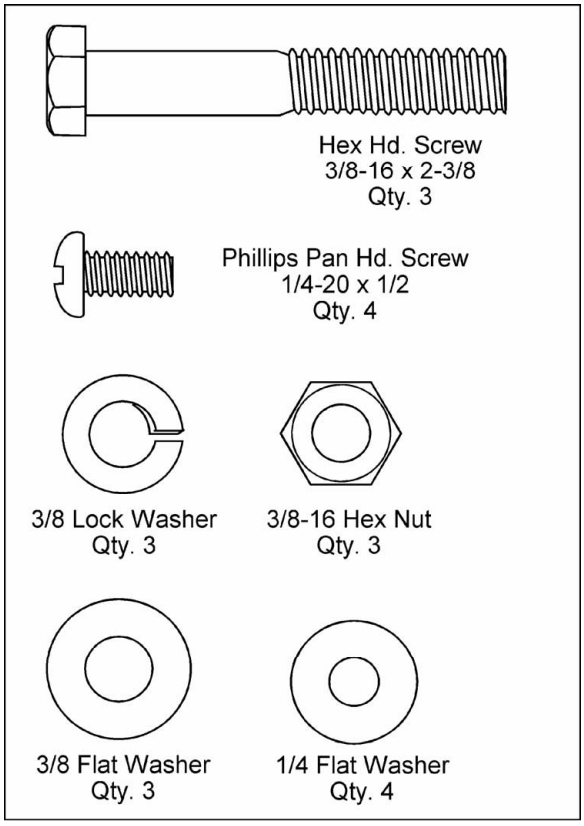


Figure 4

Installation and Assembly

NOTE: If any procedure described below needs further clarification, consult the assembly drawings at the back of this manual.

Tools required for assembly:

9/16" wrench
12mm wrench
screwdriver (phillips or flat head)

Locate the jointer on a level floor. If using a mobile base, be sure to lock the wheels before assembling, operating or adjusting the jointer.

1. With help from an assistant, lift the jointer base assembly onto the stand, matching the 3-hole pattern in the table base to that in the stand.
2. Secure jointer base to stand with three 3/8 x 2-3/8 bolts, six 3/8 flat washers, three 3/8 lock washers and three 3/8 hex nuts (Figure 5). Tighten with 9/16" wrench.

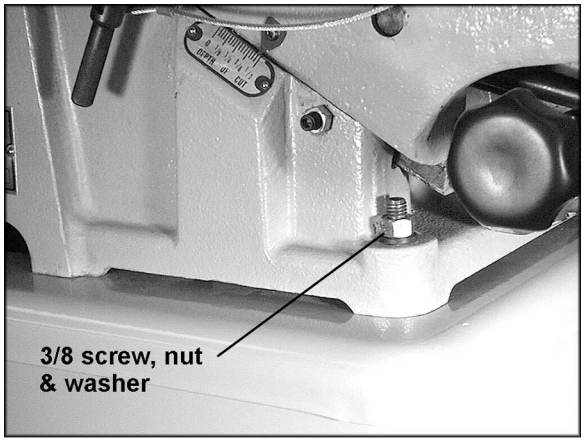


Figure 5

3. The stand can be secured to the floor using two anchor bolts (not provided) through the holes inside the bottom of the stand.

Aligning Pulleys

Place a straight edge against the motor pulley and cutterhead pulley to make sure they are aligned. If adjustment is necessary, loosen the set screws in the motor pulley, and slide it as needed until alignment is achieved. Re-tighten set screws.

Mounting Drive Belt

1. Place the belt into the groove of the cutterhead pulley.
2. Reach through the dust chute opening in the side of the stand with a 12mm wrench, and loosen the nuts on the motor mount screws (Figure 6).
3. Lift up on the motor to provide slack, and place the lower end of the drive belt into the motor pulley groove.
4. Let the motor slide down and push down on it until the belt is properly tensioned. NOTE: There should be only moderate deflection in the belt midway between the pulleys when using light finger pressure (Figure 7).
5. Tighten the four hex nuts on the motor mount screws.

Mounting Pulley Guard

Place the pulley guard (A, Figure 8) as shown, and secure with knob (B, Figure 8).

Mounting Dust Chute

It is strongly recommended that a dust collection system (not provided) be connected to the jointer. It will help keep your shop clean, and reduce the risk of health problems due to wood dust. The dust collector should have sufficient capacity for this size jointer.

Place the dust chute over the opening in the jointer stand, and secure with four 1/4-20 x 1/2 pan head screws and four 1/4 flat washers (Figure 9)

Connect a dust collection hose to the dust chute on the jointer and secure it with a hose clamp or duct tape. NOTE: Dryer vent hose is not acceptable for this purpose.

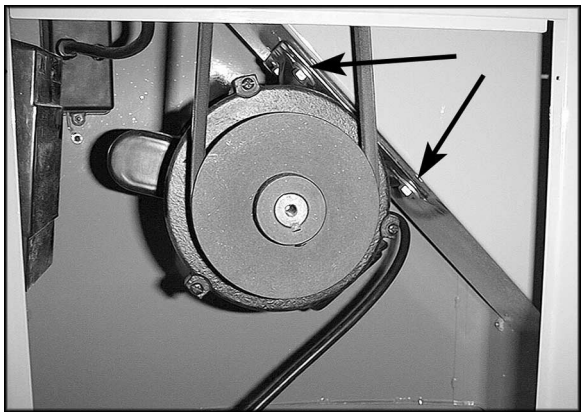


Figure 6

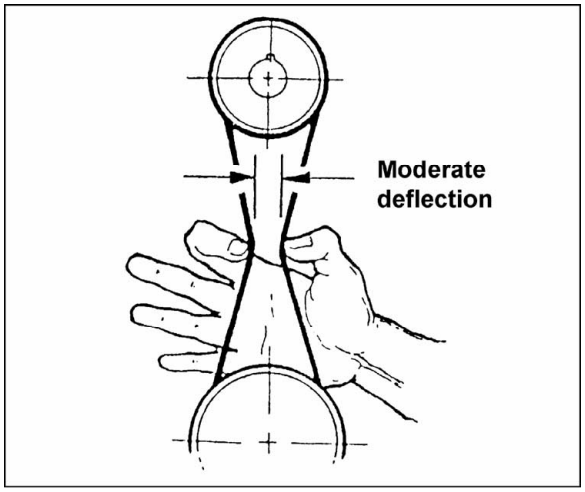


Figure 7

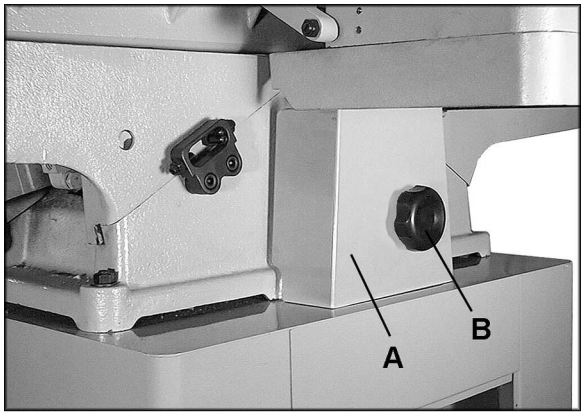


Figure 8

Figure 9

Electrical Connections

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

The Jointer is equipped with either a single phase, 230 volt motor; or a three phase, 230/460 volt motor. The ***single phase*** unit is factory wired for 230 volts. You may either install a UL/CSA listed plug suitable for 230 volt operation, or "hard-wire" the jointer directly to a service panel. The circuit for the machine should be a dedicated circuit.

The ***three phase*** motor is pre-wired for 230 volt. It may be re-connected for 460 volts by changing the connections as illustrated in the diagram in the motor wiring box (see "Converting from 230 Volt to 460 Volt"). You may either install a UL/CSA listed plug suitable for the specific voltage, or "hard-wire" the jointer directly to a service panel.

If the jointer is to be hard-wired to a panel, make sure a disconnect is available for the operator. During hard-wiring of the machine, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the jointer will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired.

Grounding Instructions

This machine must be grounded. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Repair or replace a damaged or worn cord immediately.

IMPORTANT: Make sure the electrical characteristics are the same on the motor nameplate and the power source, and make sure the circuit on which the jointer will be used is properly fused and that the wire size is correct.

Converting from 230 Volt to 460 Volt (Three Phase Only)

Consult the wiring diagram inside the starter box cover. A diagram is also included on pages 37-38 of this manual. The Jointer must comply with all local and national codes after being wired.

1. Remove the starter box cover and adjust the dial on the relay (see Figure 10) as close as possible to the amperage of the Jointer motor at 460V, as listed on the motor plate.
2. Move the fuse (Figure 10) from the 230V slot to the 460V slot.
3. Re-connect the incoming leads to the motor for 460 volt operation, as shown in the wiring diagram.
4. If using a plug, install a proper UL/CSA listed plug suitable for 460 volt operation.

Three-Phase Test Run

On the **three-phase** unit, after wiring has been completed, you should check that the incoming leads have been connected properly:

1. Connect machine to power source and press the start button (make sure cutterhead is clear of all obstructions!).
2. The cutterhead should rotate clockwise as viewed from the front of the machine. If the cutterhead rotation is incorrect, press the stop button and **disconnect machine from power.**
3. Switch any two of the three leads to the motor.

Extension Cords

Make sure your extension cord is in good condition. Always use a cord that is heavy enough to carry the current your product will draw; the cord rating must be suitable for the amperage listed on the machine's motor plate. An undersize cord will cause a drop in line voltage resulting in loss of power and overheating.

Use the chart in Figure 11 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

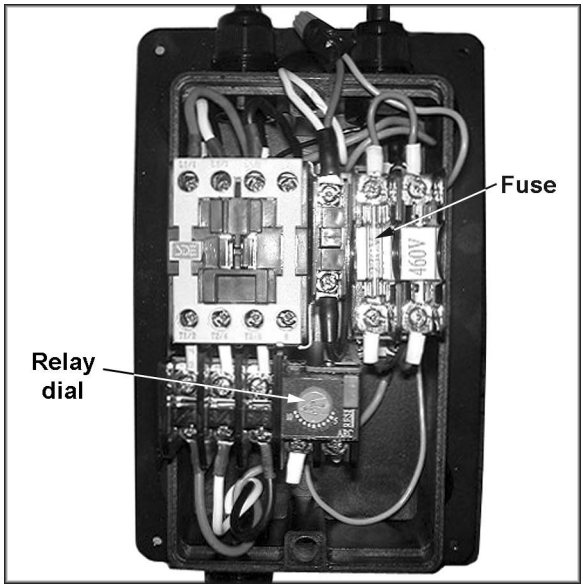


Figure 10

Extension Cord Recommended Gauges (AWG)

Amps	Extension Cord Length *					
	25 feet	50 feet	75 feet	100 feet	150 feet	200 feet
< 5	16	16	16	14	12	12
5 to 8	16	16	14	12	10	NR
8 to 12	14	14	12	10	NR	NR
12 to 15	12	12	10	10	NR	NR
15 to 20	10	10	10	NR	NR	NR
21 to 30	10	NR	NR	NR	NR	NR

*based on limiting the line voltage drop to 5V at 150% of the rated amperes.
NR: Not Recommended.

Figure 11

Adjustments

⚠WARNING Disconnect machine from power source before making adjustments.

Tools required for adjustments:

8mm & 12mm wrenches
4mm hex wrench
machinist's protractor or adjustable square
steel straight edge

Cutter Guard

Removing Guard:

Some adjusting procedures, as well as rabbeting operations, will require removal of the guard. Simply loosen handle on rabbeting ledge (Figure 12) and vertically lift guard out of the hole.

Mounting Guard:

The guard is spring tensioned. When mounted, it must have enough tension to completely cover the cutterhead, and press firmly against the fence. To adjust the guard tension:

1. Disconnect machine from power source.
2. Release the fence locking handle (A, Figure 13) and remove the two hex nuts and washer (B, Figure 13) which hold the fence to the fence support. Lift up the fence assembly and set it out of the way of the cutter guard.
3. Rotate the cutter guard (A, Figure 13) to the right and set it into its hole as shown. Firmly tighten the handle (B, Figure 13). The farther to the right you set the guard, the stronger tension it will have.
4. Rotate the guard counterclockwise (C, Figure 14) until it covers the cutterhead. **NOTE: Keep hands away from knives!** Hold it in this position (using an assistant or block of wood) and re-mount the fence.
5. Test the tension by swinging the guard away from the fence and then releasing it. The guard should snap back to the fence.

NOTE: The guard must operate freely and must not drag on the rabbeting ledge or infeed table. If dragging occurs, check that the handle (Figure 12) is tight. If guard still drags, the guard assembly may need to be replaced.

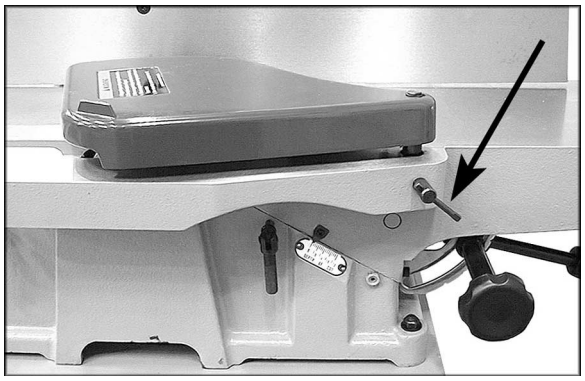


Figure 12

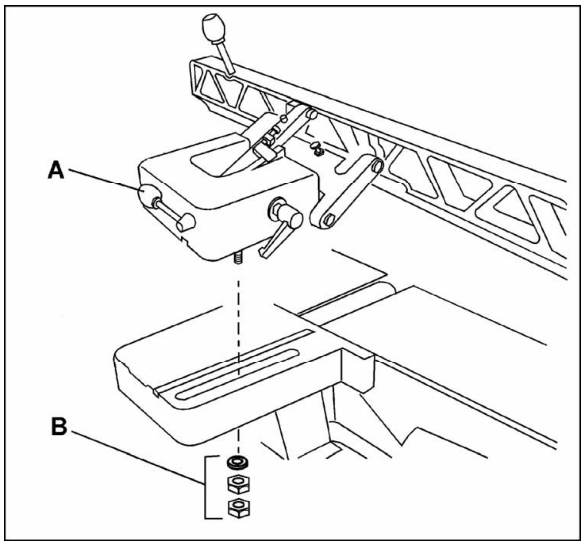


Figure 13

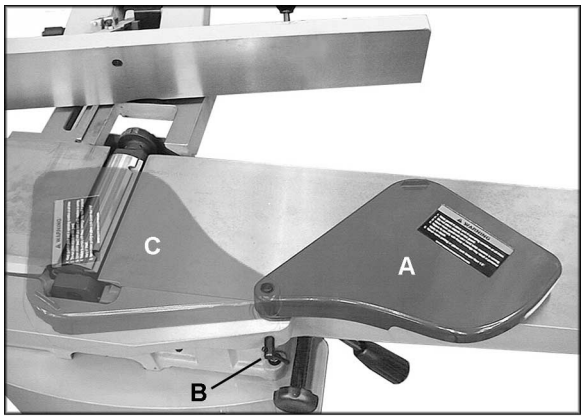


Figure 14

Installing Knives

⚠CAUTION Use care when working with or around sharp knives. Make sure power to the machine has been disconnected.

When installing new knives, remove only one knife at a time. Clean the knife slot and install the new knife. Adjust and snug new knife in cutterhead before proceeding to next knife.

1. Disconnect machine from power source.
2. Remove the belt guard so that you can rotate the cutterhead by turning the motor pulley or by moving the drive belt. **Do not** grab the cutterhead itself to rotate it.
3. Remove the old knives by loosening gib screws with an 8mm wrench, and allowing the springs to push the knife upward. Remove knife and gib. See Figure 15.
4. Clean the gib and the knife slot. Sandwich new knife and gib together and drop into slot. Make sure the knife is oriented properly as shown in Figure 15.

IMPORTANT: To position the knives for rabbet cuts, take a shop scale with 1/32" graduations and place it against the end of the cutterhead. Slide the knife out until it is at the 1/32" mark on the scale; that is, the knife will now be 1/32" beyond the edge of the cutterhead. The gib should remain in normal position, even with the edge of the cutterhead. See Figure 16. This adjustment will ensure that the knife clears the end of the gib and cutterhead, and has good contact with the workpiece. (See under “Basic Jointer Operation” for further information on rabbeting procedures.)

5. The height of the knife in the slot, both for rabbeting and normal jointer work, must now be set properly, to ensure correct operation as well as minimize the hazard of kickback. Proceed as follows:
6. Rotate the cutterhead (using the pulley) until the tip of the knife is at the top of the cutterhead arc. Place the knife setting gauge (Figure 17) over the cutterhead so the tip of the knife contacts the center of the gauge, and all four "feet" of the gauge rest firmly upon the cutterhead, as the knife is pushed down into its slot. The gauge will set the knives at approximately .070" above the cutterhead. Knife height should not vary more than .002-.003" across the length of the cutterhead.

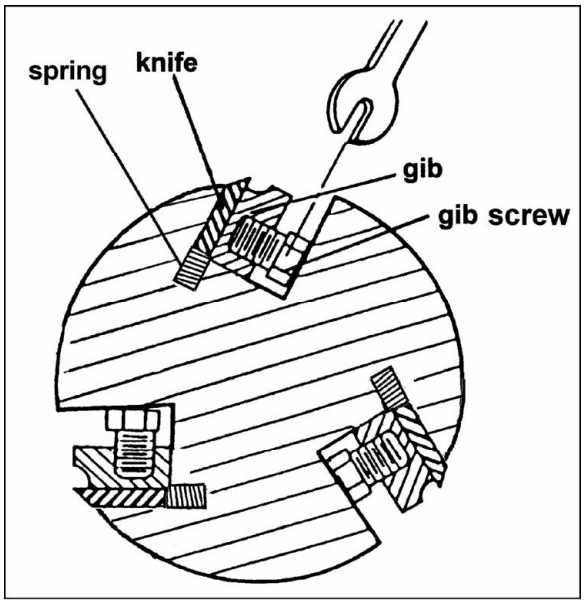


Figure 15

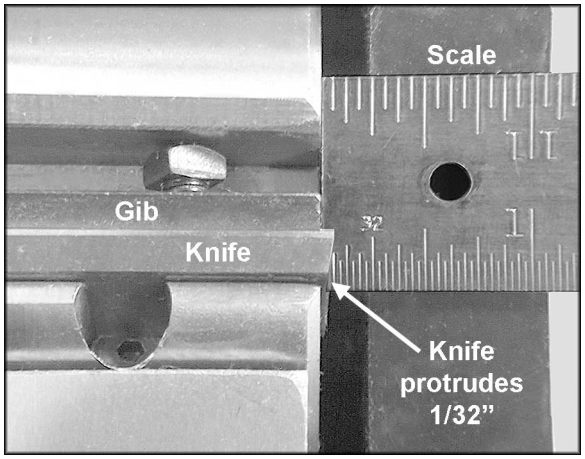


Figure 16

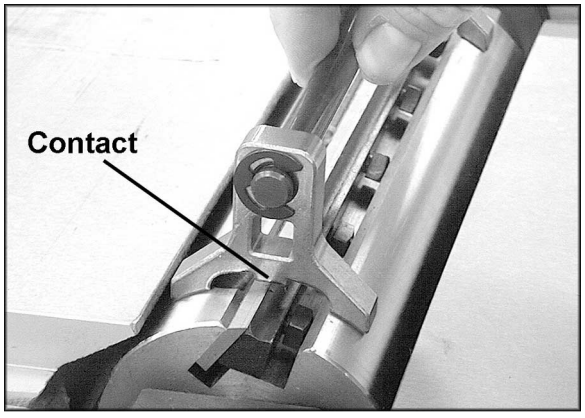


Figure 17

7. Tightening the gib screws should be done in increments, to prevent any distortion to the cutterhead or buckling of knives. While holding the gauge down on one knife, snug down the five gib screws, beginning with the center screw and working your way to the ends. Do not fully tighten yet.
8. Rotate the cutterhead to the next slot and repeat step #6, only making the knives snug. Repeat for the third knife.
9. The tightening process should continue at least two more times, each time tightening the screws more on all three knives. On the third time, they should all be firmly tightened.

⚠WARNING Before starting jointer, make sure all gib screws are firmly tightened. A loose knife thrown from the cutterhead can cause severe or fatal injury.

10. After replacing knives, the outfeed table must be checked and adjusted so that it is level with the high point of the knives. See "Setting Outfeed Table" on page 16.

Leveling Tables

The tables have been leveled with each other from the factory, but this should be confirmed by the user, and checked periodically, by placing a steel straight edge across both tables. If tables are not level, this may be the result of loose gibs. Correct as follows:

1. Loosen hex nuts on the gib screws (A, Figure 18) with a 12mm wrench, then loosen the gib screws with a 4mm hex wrench. Loosen the table lock handle (B, Figure 18).
2. Remove lower hex nut and gib screw (A*, Figure 18) and check screw hole to make sure that punch mark in the gib is aligned with the screw hole. If punch mark is not visible, or it does not line up with screw hole, use a screwdriver to lightly tap the gib back into alignment.
3. Replace the lower gib screw (A*, Figure 18) but do not tighten.
4. Carefully tighten the table lock screw (B, Figure 18). The table will begin to move toward the straight edge.
5. When aligned, re-set the gib screws (A, Figure 18) until tight. If table does not align with straight edge, use the adjusting arm (C, Figure 18) for the infeed table, or handwheel (D, Figure 18) for the outfeed table, until the table is flush with the straight edge.

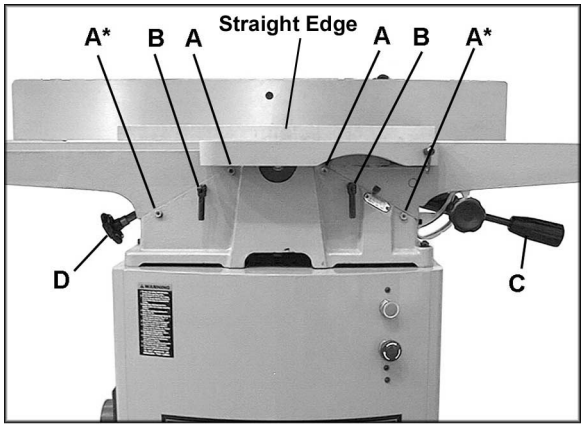


Figure 18

6. Tighten the gib screws (A, Figure 18) then back them off approximately 1/4 turn or until the table moves freely, and re-set the lock nuts on the gib screws.

If table will still not line up:

Remove gib screws and table locking handle and remove gib (#16, page 29). Check gib to see that set screws do not go all the way through the gib or dimple the opposite side. If either of these conditions exist, replace with a new gib.

Also, check to be sure the ways are clean and free of pitch and sawdust. Lubricate gib and way with a good grade of non-hardening grease.

Replace the gib, making certain that the punch mark lines up with the locking screw holes. Replace gib screws. Repeat steps 3 through 6.

Adjusting Depth of Cut

Depth of cut is determined by the height of the infeed table relative to the cutterhead. Setting the infeed table is achieved with both a rapid adjust and a fine adjust.

Rapid Adjust:

1. Loosen the lock screw (A, Figure 19) and the locking handle (B, Figure 19).
2. Raise or lower the height adjustment handle (C, Figure 19) until the scale (D-Figure 19) reads approximately the correct depth of cut.

Fine Adjust:

3. Rotate the locking handle (B, Figure 19) until it is snug, then fine-tune the adjustment by rotating the height adjustment handle (C, Figure 19) until the scale reads exact. (Clockwise raises the table, counter-clockwise lowers the table.) A full rotation of the fine adjustment handle equals 1/16" travel of the infeed table.
4. When set, re-tighten lock screw (A, Figure 19).

Periodically check the accuracy of the depth of cut scale (D, Figure 19) by raising the infeed table until it is flush with the peak of the cutterhead arc (using a straight edge across table and cutterhead). The scale should read zero depth. If it does not, re-adjust the pointer above the scale.

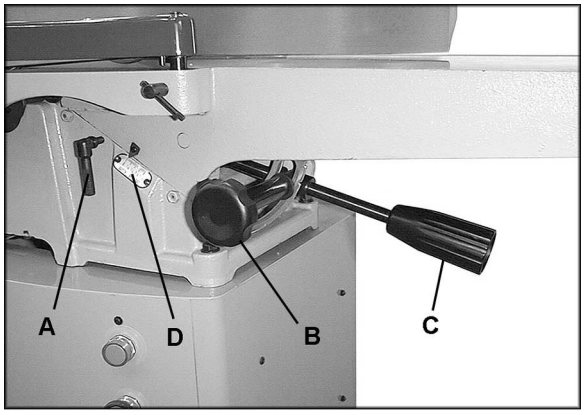


Figure 19

Setting Outfeed Table

For accurate work in most jointing operations, the outfeed table must be exactly level with the knives at their highest point of revolution.

1. Raise the outfeed table to its highest point, and place a straight edge across it.
2. Rotate the cutterhead (using the belt or pulley) until one knife is at its highest point.
3. Lower the outfeed table until the straight edge contacts a knife. Rock the cutterhead slightly to make sure the apex of the knife is contacting the straight edge. Lock the outfeed table at that setting.

After the outfeed table has been set at the correct height, it should not be changed except for special operations or after replacing knives.

Examples of incorrect settings:

If the outfeed table is too high, the finished surface of the workpiece will be curved (Figure 20).

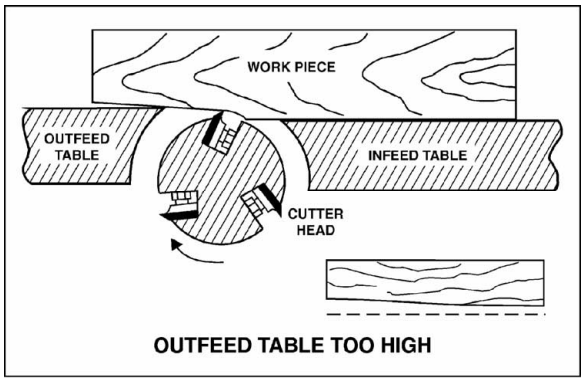


Figure 20

If the outfeed table is too low, the work will be gouged at the end of the cut (Figure 21)

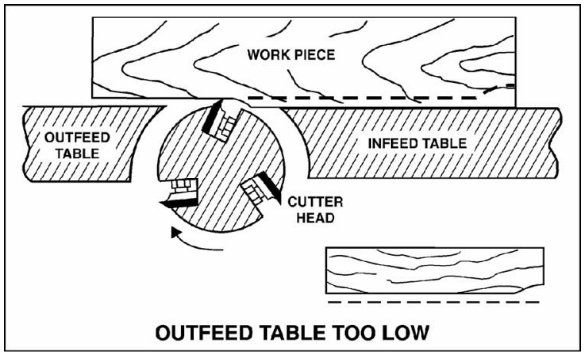


Figure 21

As a final check of the outfeed table adjustment, run a piece of wood slowly over the knives for 6 to 8 inches; it should rest firmly on both tables (Figure 22) with no open space under the finished cut.

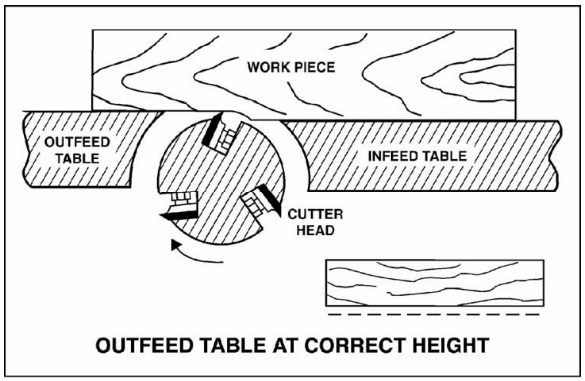


Figure 22

Spring Cutting

To spring cut, the outfeed table is lowered below the level of the cutterhead, as in Figure 23. Loosen both gib screws (A, Figure 23) on the outfeed table. Amount of end-drop is controlled with the table lock screw (B, Figure 23). Tighten handle to reduce amount of drop. A 1/32" drop usually creates the ideal concave for spring joints. After completing a spring cut, return the outfeed table in line with the cutterhead knives.

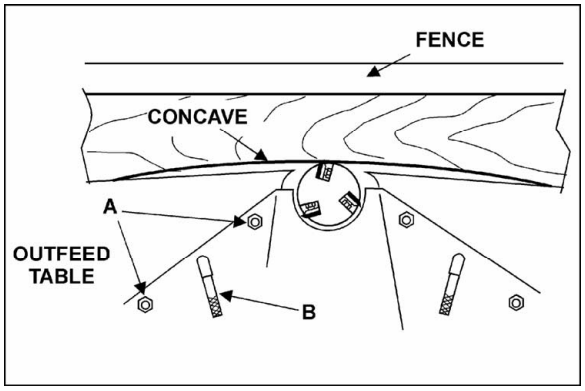


Figure 23

Fence Movement

To slide the fence forward or backward on the table, loosen lock handle (A, Figure 24), slide the fence to desired position and tighten lock handle to secure fence. **Lift up on fence when tilting or sliding, to prevent scratching the table.**

NOTE: The handle (A, Figure 24) may be adjusted to a more convenient position by loosening the hex nuts below the casting (see B, Figure 31), turning the handle to the proper position, and retightening the hex nuts.

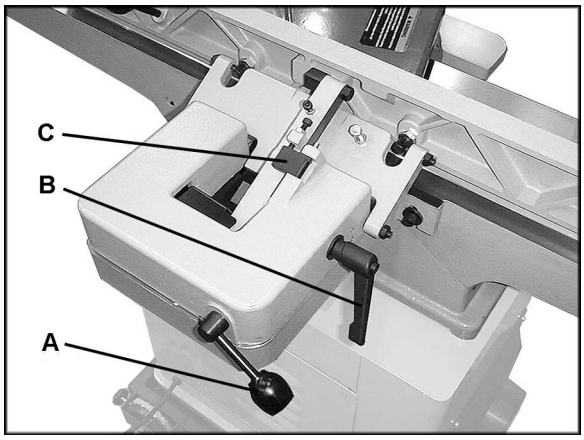


Figure 24

To tilt the fence **forward**:

1. Loosen locking handle (B, Figure 24).
2. Place an angle measuring device on the table and against the fence. Tilt the fence to desired angle and tighten locking handle (B, Figure 24) to secure the angle.

To tilt the fence **back**:

1. Loosen locking handle (B, Figure 24).
2. Flip the stop block (C, Figure 24) out of the way.
3. Tilt the fence to desired angle and tighten locking handle (B, Figure 24) to secure angle.

⚠CAUTION When the tilted operation is finished and the fence is returned to 90 degrees, do not forget to flip the stop block back to its original position.

Fence Stops

Periodically check the 90 degree and 45 degree tilt accuracy of the fence with an adjustable square or machinist's protractor. If adjustments are necessary, proceed as follows:

90 degree stop:

1. The 90 degree stop is controlled by the screw (D, Figure 25).
2. Loosen the locking handle (B, Figure 25) and the hex nut on the screw (D, Figure 25).
3. Set the square on the table and against the fence, and move the fence to fit flush against the 90 degree angle. Rotate the screw (D, Figure 25) until it contacts the stop block (C, Figure 25).
4. Tighten the hex nut (D, Figure 25) and the locking handle (B, Figure 25).

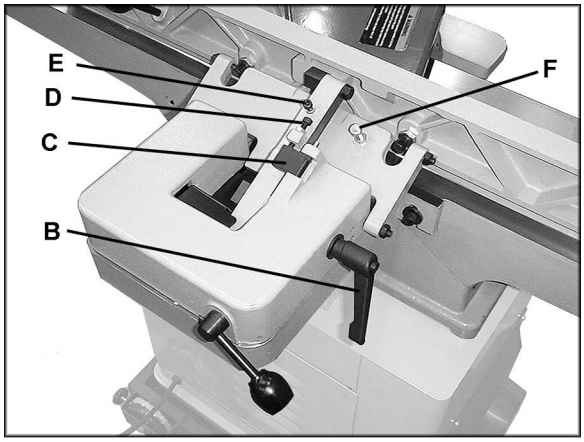


Figure 25

45 degree forward stop:

1. The 45 degree forward stop is controlled by the screw (E, Figure 25).
2. Loosen the locking handle (B, Figure 25) and the hex nut on the screw (E, Figure 25).
3. Set the 45 degree protractor on the table and against the fence, and tilt the fence until it is flush against the 45 degree angle.
4. Rotate the screw (E, Figure 25) until it contacts the casting below it.
5. Tighten hex nut (E, Figure 25) and locking handle (B, Figure 25).

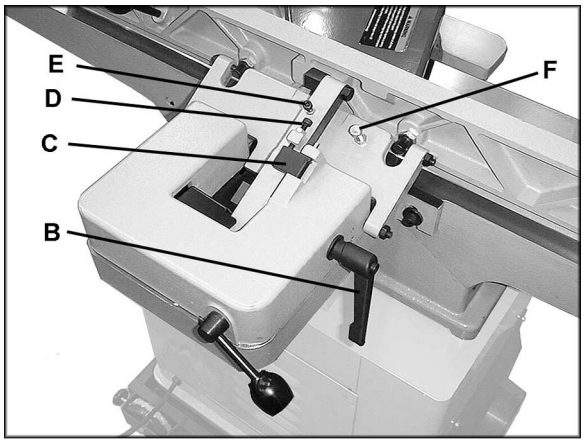


Figure 25 (repeated)

45 degree back stop:

1. Flip the stop block (C, Figure 25) out of the way.
2. The 45 degree back stop is controlled by the screw (F, Figure 25).
3. Loosen the locking handle (B, Figure 25) and the hex nut on the screw (F, Figure 25).
4. Use a protractor set at 45 degrees beyond the right angle (a total of 135 degrees) and place it on the table and against the fence. Tilt the fence until it is flush with the protractor.
5. Rotate the screw (F, Figure 25) to the proper height.
6. Tighten hex nut (F, Figure 25) and locking handle (B, Figure 25).

Basic Jointer Operation

NOTE: If you are inexperienced at jointing, use scrap pieces of lumber to check settings and get the feel of operations before attempting regular work.

This section briefly discusses general rules as well as some of the basic cuts using a jointer, such as surfacing, edging, beveling, skewing, rabbeting and taper cuts.

⚠WARNING Always use cutterhead guard (except during rabbeting) and keep hands away from cutterhead.

Jointing Short or Thin Work

When jointing short or thin pieces, use a push pad or push block to eliminate all danger to the hands. Two push pads are included with your jointer. You can also make your own push block from scrap material. Three types are illustrated in Figure 26.

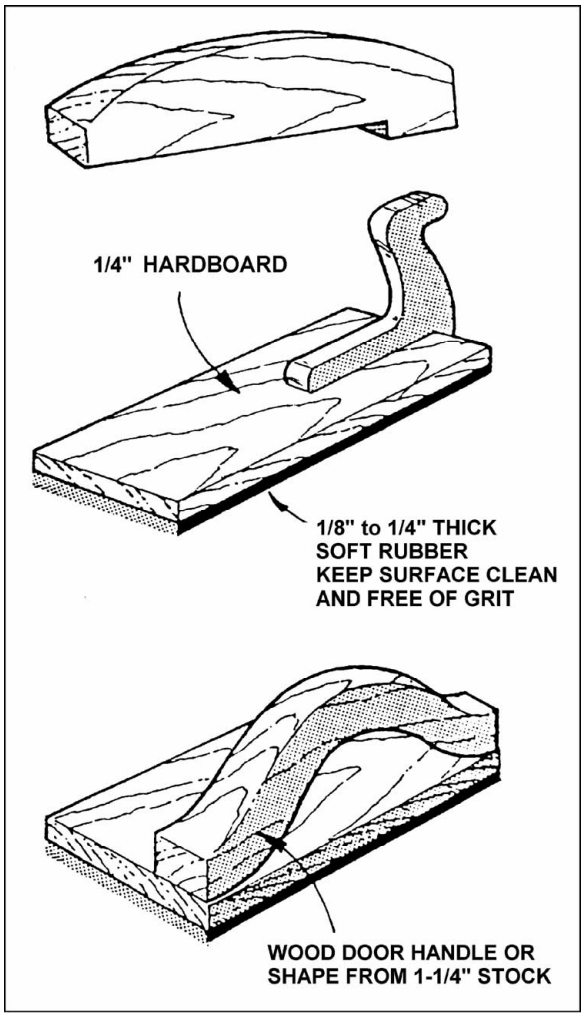


Figure 26

Direction of Grain

Avoid feeding work into the jointer against the grain. This will result in chipped and splintered edges (Figure 27). Feed with the grain to obtain a smooth surface (Figure 28).

Hand Placement

At the start of the cut, the left hand holds the work firmly against the infeed table and fence while the right hand pushes the work toward the knives. After the cut is under way, the new surface rests firmly on the outfeed table. The left hand should press down on this part, at the same time maintaining flat contact with the fence. The right hand presses the work forward and before the right hand reaches the cutterhead it is moved to the work on the outfeed table. **Follow the 3 inch rule. Never pass hands directly over the cutterhead.**

Surfacing

Jointing the face of stock, or surfacing, is shown in Figure 29. The use of push blocks or pads will help ensure against the operator's hands coming into contact with the cutterhead in the event of a kickback, or as the trailing end of the board passes over the cutterhead.

Adjust the infeed table for depth of cut. Cuts of approximately 1/16" at a time are recommended, as this allows better control over the material being surfaced. More passes can then be made to reach the desired depth.

Never surface pieces shorter than 12" or thinner than 3/8" without the use of a special work holding fixture.

IMPORTANT: When stock is longer than twice the length of the infeed and outfeed tables, an assistant or support table must be used to support the stock.

⚠WARNING Always use a hold down or push block when surfacing short stock or stock less than 3 inches thick.

Jointing Warped Surfaces

If the wood to be jointed is dished or warped, take light cuts until the surface is flat. Avoid forcing such material down against the table; excessive pressure will spring it while passing the knives, and it will spring back and remain curved after the cut is completed.

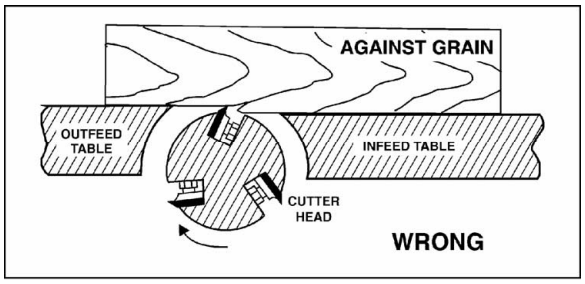


Figure 27

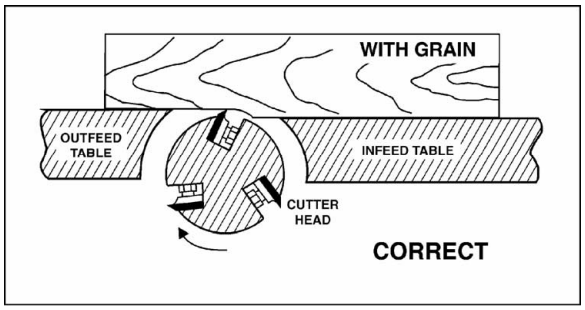


Figure 28

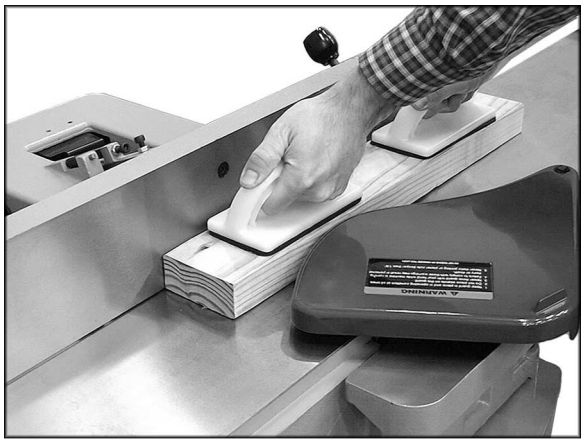


Figure 29

Edge Jointing

This is the most common operation for the jointer. Set guide fence square with the table. Depth of cut should be the minimum required to obtain a straight edge. Do not make cuts deeper than 1/8" in a single pass. Hold the best face of the piece firmly against the fence throughout the feed. See Figure 30.

When edging stock wider than 3 inches, lap the fingers over the top of the wood, extending them back over the fence so that the fence casting will act as a stop for the hands in the event of a kickback.

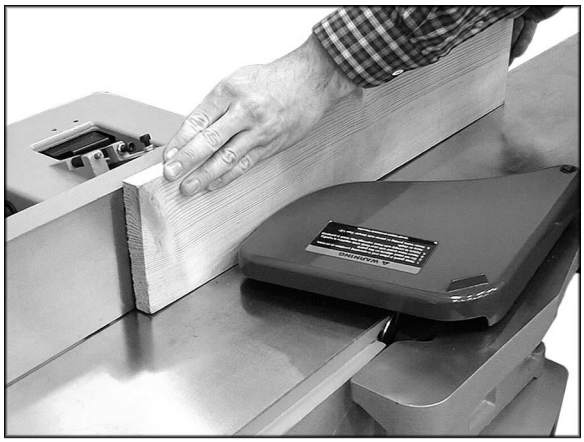


Figure 30

Beveling

When beveling never make cuts deeper than 1/16 inch. Make certain material being beveled is over 12 inches long, more than 1/4" thick and 1" wide.

⚠CAUTION Although the fence may be tilted in or out for a bevel cut, It is recommended for safety reasons that the fence be tilted in toward the operator, making a cradled cut.

Set fence to desired angle. For stock wider than 3", hold with the fingers close together near the top of the stock, lapping over the board and extending over the fence. When beveling material less than 3" wide, use beveled push blocks.

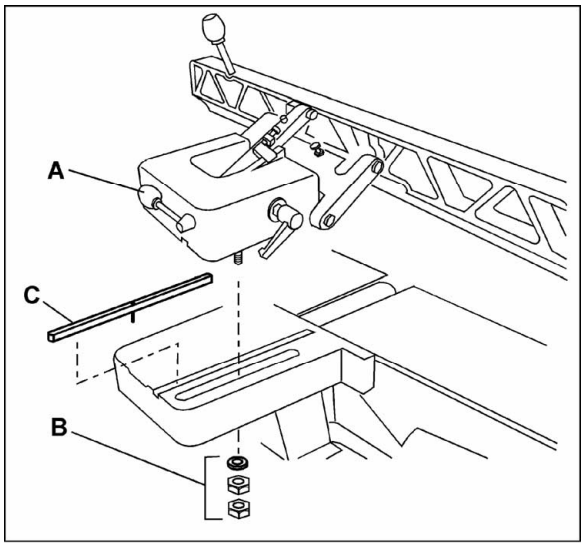


Figure 31

Skewing (Shear Cutting)

When edging or facing burl or birds-eye maple, it is not unusual to deface or mar the surface being finished. This is caused by the cutterhead blades at times cutting against the grain. In order to prevent the defacing or marring of this type wood, it is necessary to skew, or angle finish, the material being worked.

1. Release the fence locking handle (A, Figure 31) and remove the two hex nuts and washer (B, Figure 31) holding the fence to the fence support. Remove the fence assembly.
2. Remove the key (C, Figure 31) from the fence support.
3. Replace the fence assembly at the desired angle across the cutterhead. See Figure 32. Secure the fence to the support with the hex nuts and washer (B, Figure 31), then tighten the fence locking handle (A, Figure 31).

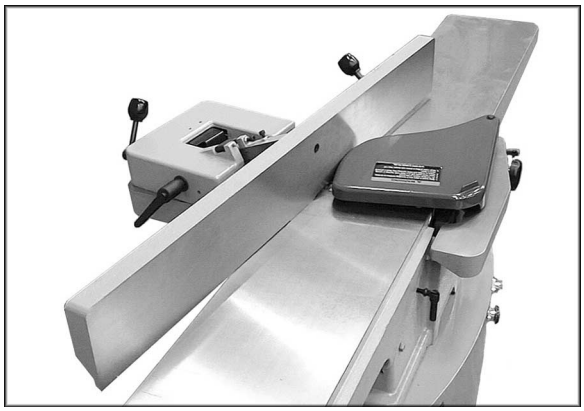


Figure 32

Taper Cuts

A useful jointer operation is cutting an edge to a taper. The method can be used on a wide variety of work. Tapered legs of furniture are a common example. Instead of laying the piece on the infeed table, lower the forward end of the work onto the outfeed table. **Do this very carefully,** as the piece will span the knives, and they will take a "bite" from the work with a tendency to kick back unless the piece is firmly held. Now push the work forward as in ordinary jointing.

The effect is to plane off all the stock in front of the knives to increasing depth, leaving a tapered surface. The ridge left by the knives when starting the taper may be removed by taking a very light cut according to the regular method for jointing, with the infeed table raised to its usual position.

Practice is required in taper operations, and the beginner is advised to make trial cuts on waste material. Taper cuts over part of the length and a number of other special operations can easily be done as the operator gains experience.

Rabbeting

⚠WARNING **A rabbet cut requires removal of the cutter guard. Use extreme caution and keep hands clear of cutterhead. Always replace guard immediately after rabbeting operation is completed.**

A rabbet is a groove cut along the edge of a board. The width and thickness of the wood to be rabbeted depends upon the width and length of the rabbet. However, never rabbet a piece of wood less than 12" long. Use push blocks to rabbet cut whenever possible.

4. Disconnect machine from power source.
5. Set fence for the desired width of the rabbet.
6. Check the width of the rabbet by measuring the distance from the end of a knife in the cutterhead to the fence.
7. Lower infeed table 1/32" at a time and make successive cuts until the desired depth of rabbet has been obtained. See Figure 33. NOTE: It is easier and safer to take a series of shallow cuts.

When *rabbeting* long pieces, follow the same procedure as for *surfacing* long pieces (page 19).

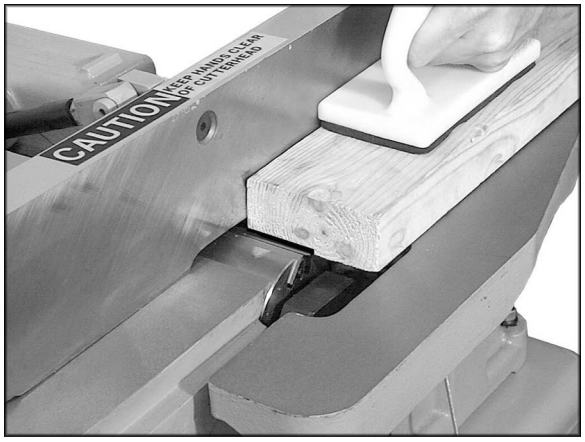


Figure 33

Maintenance

⚠WARNING Disconnect machine from power source before doing any maintenance.

The table and fence surfaces must be kept clean and free of rust for best results. Some users prefer a paste wax coating. Another option is talcum powder applied with a blackboard eraser rubbed in vigorously once a week; this will fill casting pores and form a moisture barrier. This method provides a table top that is slick and allows rust rings to be easily wiped from the surface. Important also is the fact that talcum powder will not stain wood or mar finishes as wax pickup does.

The fence assembly should slide easily over the fence support. Keep fence support greased.

The bearings in the cutterhead are sealed and do not require lubrication.

Gum and pitch which collect on the knives cause excessive friction as the work continues, resulting in overheating of the knives, less efficient cutting, and consequent reduction in the life of the knives. Use an oven cleaner or gum and pitch remover to wipe this off the knives.

Sharpening Knives

Knives should be kept sharp. This will contribute to better stock finish, longer machine life, and safer operation.

A jointer knife hone provides a simple way to sharpen knives. Hones are available from many woodworking supply stores. Carefully read any instructions that accompany the hone.

⚠WARNING Use caution and proceed slowly when sharpening knives. Disconnect jointer from power source, and wear approved eye protection.

When finished sharpening knives, they should be re-set level to the outfeed table. See “Installing Knives” on page 13.

Knives can usually be whetted several times in the cutterhead before having to be removed and re-ground.

TIP: If the jointer is used frequently, keeping a spare set of knives on hand is recommended. Extra knives (stock no. 6427002, set of 3) may be obtained from your Powermatic distributor, or by calling WMH Tool Group at 1-800-274-6848.

Cutterhead Repairs

The entire cutterhead assembly may be removed for bearing replacement or other maintenance procedures.

1. Disconnect jointer from power source.
2. Remove fence assembly from jointer (see page 12, Figure 13).
3. Loosen motor mounting and push up on motor to create slack in belt (see page 9)
4. Remove drive belt from cutterhead pulley.
5. Lower both infeed and outfeed tables.
6. Loosen the two socket head cap screws on the fence support and pivot the fence support out of the way (Figure 34).

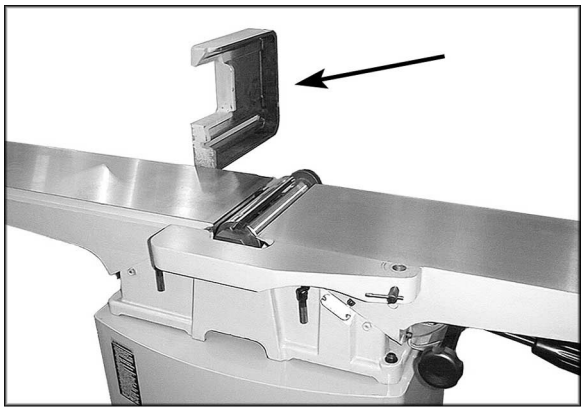


Figure 34

7. Remove rabbeting ledge by loosening the two hex cap screws and washers (A, Figure 35).

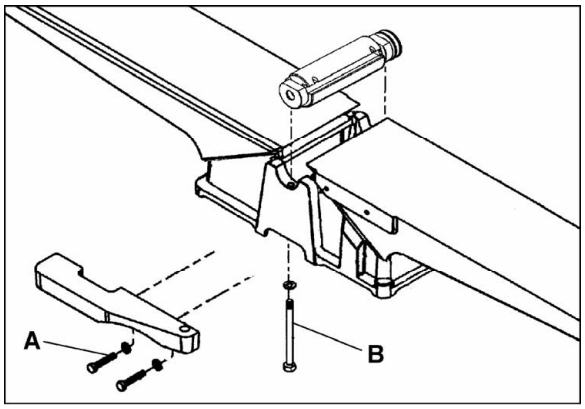


Figure 35

8. Loosen the two bolts (B, Figure 35) that secure the cutterhead to the bed – these are accessed from the underside of the bearing blocks.
9. Lift cutterhead straight up from base.
10. Remove pulley and both bearing housings.

IMPORTANT: If the bearings need replacement, this should be done by qualified service personnel. The bearings are press fitted and must be removed with an arbor press.

To re-install cutterhead, reverse the above procedure. Before re-installing, make sure the machine's curved seats of the base casting are free of dirt, dust or grease, to help ensure a tight fit.

NOTE: Whenever the cutterhead is re-installed on the jointer, the tables must be leveled in relationship to it.

You may wish to keep an extra cutterhead on hand to maintain shop productivity.

Table Removal

1. Disconnect jointer from power source.
2. Remove fence assembly except for the support casting.
3. Remove cutter guard.
4. Lower infeed and outfeed tables and remove cutterhead.
5. Loosen the gib set screws and table lock screws.

⚠CAUTION **After gib screws are loosened, table could suddenly slide down.**

6. Remove infeed or outfeed table by sliding upward.

Troubleshooting – Operating Problems

Trouble	Probable Cause	Remedy
Finished stock is concave on back end.	Knife is higher than outfeed table.	Raise outfeed table until it aligns with tip of knife. See page 16.
Finished stock is concave on front end.	Outfeed table is higher than knife.	Lower outfeed table until it aligns with tip of knife. See page 16.
Stock has slight bevel after edge jointing.	Fence not perpendicular to table.	Square up fence with table.
Chip out.	Cutting against the grain.	Cut with the grain whenever possible.
	Dull knives.	Sharpen or replace knives.
	Feeding workpiece too fast.	Use slower rate of feed.
	Cutting too deeply.	Make shallower cuts.
	Knots, imperfections in wood.	Inspect wood closely for imperfections; use different stock if necessary.
Fuzzy, rough, or torn grain.	Wood has high moisture content.	Allow wood to dry or use different stock.
	Dull knives.	Sharpen or replace knives.
	Knives are cutting against grain.	Cut with the grain.
Board thickness does not match depth of cut scale.	Depth of cut scale is incorrect.	Adjust scale correctly.
Cutterhead slows while operating.	Feeding too quickly, or applying too much pressure to workpiece.	Feed more slowly, or apply less pressure to workpiece.
	Excessive depth of cut.	Reduce depth of cut.
	Dull knives.	Sharpen or replace knives.
“Chatter” marks on workpiece.	Knives incorrectly set.	Set knives properly using provided knife setting gauge. Check that knife slots are clean and free of dust or debris.
	Feeding workpiece too fast.	Feed workpiece slowly and consistently.
Uneven knife marks on workpiece.	Knives are nicked, or out of alignment.	Replace nicked knives; align knives properly using knife-setting gauge. See page 13.

Troubleshooting – Mechanical and Electrical Problems

Trouble	Probable Cause	Remedy
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	No incoming power.	Verify unit is connected to power, on-button is pushed in completely, and stop-button is disengaged.
	Overload automatic reset has not reset.	When jointer overloads on the circuit breaker built into the motor starter, it takes time for the machine to cool down before restart. Allow unit to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter inside the electrical enclosure – it should match the amps on the motor as indicated on the motor plate.
	Jointer frequently trips.	One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to take a lighter cut. If too deep a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is correct then there is probably a loose electrical lead.
	Building circuit breaker trips or fuse blows.	Verify that jointer is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter.
	Switch or motor failure (how to distinguish).	Examine motor starter for burned or failed components. If damage is found, replace starter. If no visible damage found, have starter tested. If you have access to a voltmeter, you can separate a starter failure from a motor failure by first, verifying incoming voltage at 220+/-20 and second, checking the voltage between starter and motor at 220+/-20. If incoming voltage is incorrect, you have a power supply problem. If voltage between starter and motor is incorrect, you have a starter problem. If voltage between starter and motor is correct, you have a motor problem.
	Motor overheated.	Clean motor of dust or debris to allow proper air circulation. Allow motor to cool down before restarting.

Trouble	Probable Cause	Remedy
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	Motor failure.	If electric motor is suspect, have it tested by qualified service personnel. Repair or replace as needed.
	Electrical leads are attached incorrectly.	Double check to confirm all electrical connections are correct. Refer to appropriate wiring diagrams on pages 36 through 38 to make any needed corrections.
	Loose electrical connections.	Inspect all motor leads for tightness. Look for any signs of electrical arcing which would indicate loose connections or circuit overload.
	On/off switch failure.	If the on/off switch is suspect, you have two options: Have a qualified electrician test the switch for function, or purchase a new on/off switch and establish if that was the problem on changeout.

Optional Accessories

2042376 ..... Mobile Base
6296046 ..... Knives (set of 3)
6285917 ..... Push Block

Replacement Parts

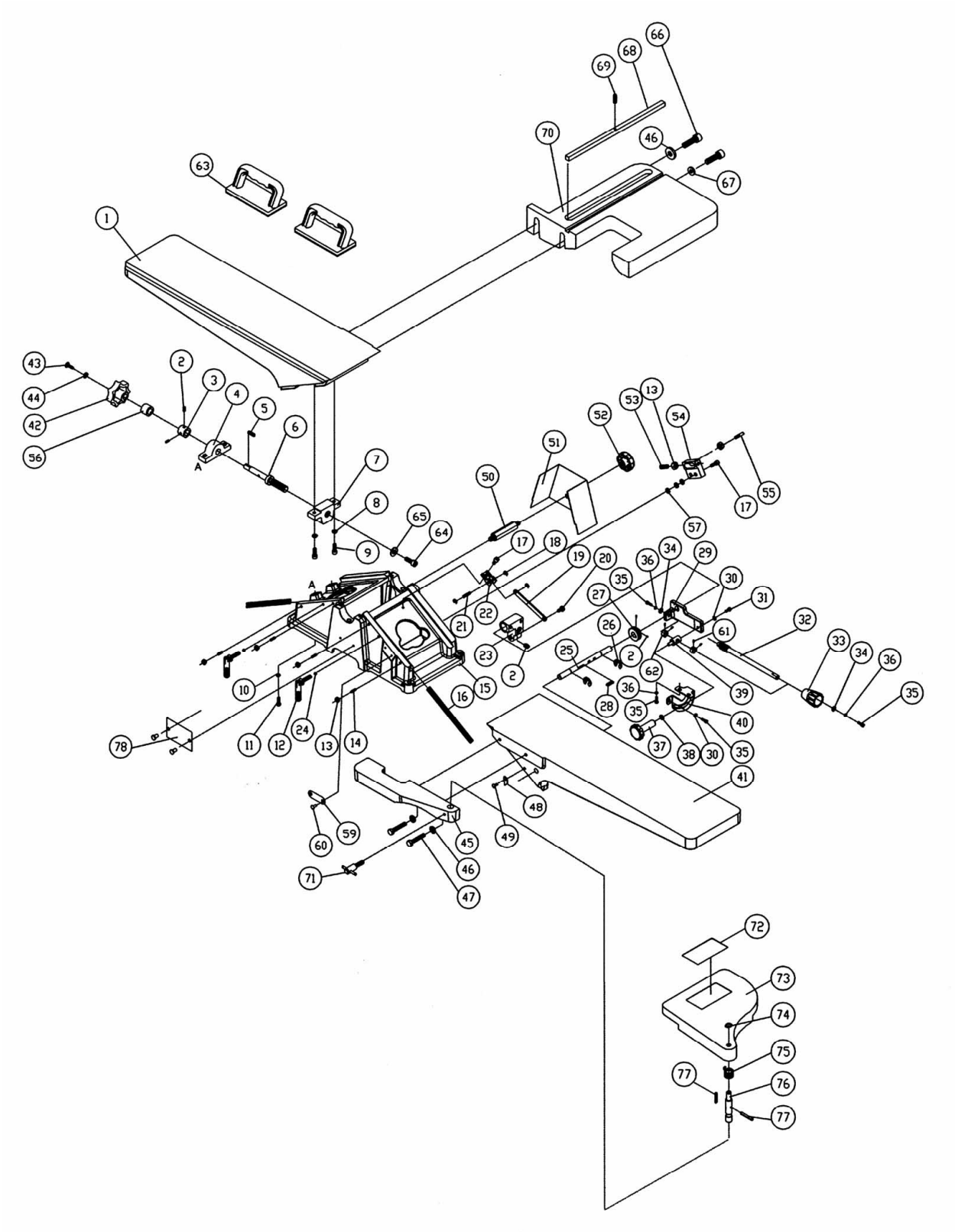
Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:30 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Parts List: Base Assembly

Index No.	Part No.	Description	Size	Qty
.....	2365022	Jointer Base Assembly (Items 1 thru 78 and fence & cutterhead assys.)		1
1	6296000	Rear Table		1
2	6285865	Set Screw	1/4”-20x3/8”	6
3	6296001	Collar		1
4	6296002	Bracket		1
5	6296003	Key	5x5x12	1
6	6296004	Lead Screw		1
7	6296005	Bracket		1
8	6285852	Lock Washer	3/8”	2
9	6296007	Cap Screw	3/8”-16x1-1/4”	2
10	6296162	Lock Washer	1/2”	2
11	6296009	Cap Screw	1/2”-12NCx1-1/2”	2
12	6296010	Bolt		2
13	6285966	Hex Nut	5/16”-18	9
14	6296011	Set Screw	1/4”-20x1”	6
15	60B-215	Base		1
16	6296013	Gib		2
17	TS-0208041	Socket Head Cap Screw	5/16”-18x3/4”	3
18	6296015	Retaining Ring	ETW-6	3
19	6296132	Bar		1
20	6296016	Bolt		1
21	6296017	Shaft		1
22	6296018	Lock Bracket		1
23	6296019	Bracket		1
24	6296020	Ball		2
25	6296021	Shaft		1
26	6296022	Retaining Ring	ETW-12	2
27	6296023	Worm		1
28	6296024	Key	5x5x20	1
29	6296025	Adjusting Base		1
30	6296160	Flat Washer	1/4”	1
31	6296027	Hex Head Bolt	1/4”-20x3/4”	1
32	6296029	Worm Shaft		1
33	6296028	Handle		1
34	6296161	Flat Washer	1/4”	2
35	6296031	Cap Screw	1/4”-20x1/2”	6
36	6296163	Lock Washer	1/4”	5
37	6296033	Clamp Knob		1
38	6296164	Flat Washer	1/2”	1
39	6296035	Lock Plate		1
40	6296036	Plate		1
41	60B-241	Front Table		1
42	6296038	Handwheel		1
43	6296039	Pan Head Screw	5/16”-18x1/2”	1
44	6296165	Flat Washer	3/8”	1
45	60B-245	Rabbeting Ledge		1
46	6296042	Flat Washer		3
47	TS-0060051	Hex Head Bolt	3/8”-16x1	2
48	6096044	Pointer		1
49	6296045	Pan Head Screw	#8-32x1/4”	1
50	6296056	Bolt		1
51	6296057	Belt Guard		1
52	6296058	Knob		1
53	TS-0270091	Set Screw	5/16”-18x1”	2
54	6296061	Set Block		1
55	6296062	Bolt		1
56	6296063	Collar		1

57	6296166	Flat Washer	5/16”	6
59	6296167	Depth Scale		1
60	VS020500	Rivet	2x5	4
61	6296152	Set Screw	1/4”-20x1/4”	4
62	6296151	Collar		2
63	6285917	Push Block		1
64	6296168	Cap Screw	5/16”-18x1/2”	1
65	6296166	Flat Washer	5/16”x3/4”D	2
66	6285931	Cap Screw	3/8”-16x1-1/2”	2
67	TS-1550071	Flat Washer	3/8”x3/4”D	1
68	6296089	Key	9.5mmx273mm	1
69	6296088	Spring Pin	4x14	1
70	6296086	Base Slide		1
71	60B-271	Stop Handle		1
	60B-270	Cutterhead Guard Assembly (Items 72 thru 77)		1
72	60B-272	Warning Label		1
73	60B-273	Cutterhead Guard		1
74	JSG96-223	Retaining Ring	STW-11	1
75	60B-275	Spring		1
76	60B-276	Shaft		1
77	60B-277	Spring Pin	6x36	2
78	60B-278	I.D. Label	1Ph	1
	60B-278A	I.D. Label	3Ph	1

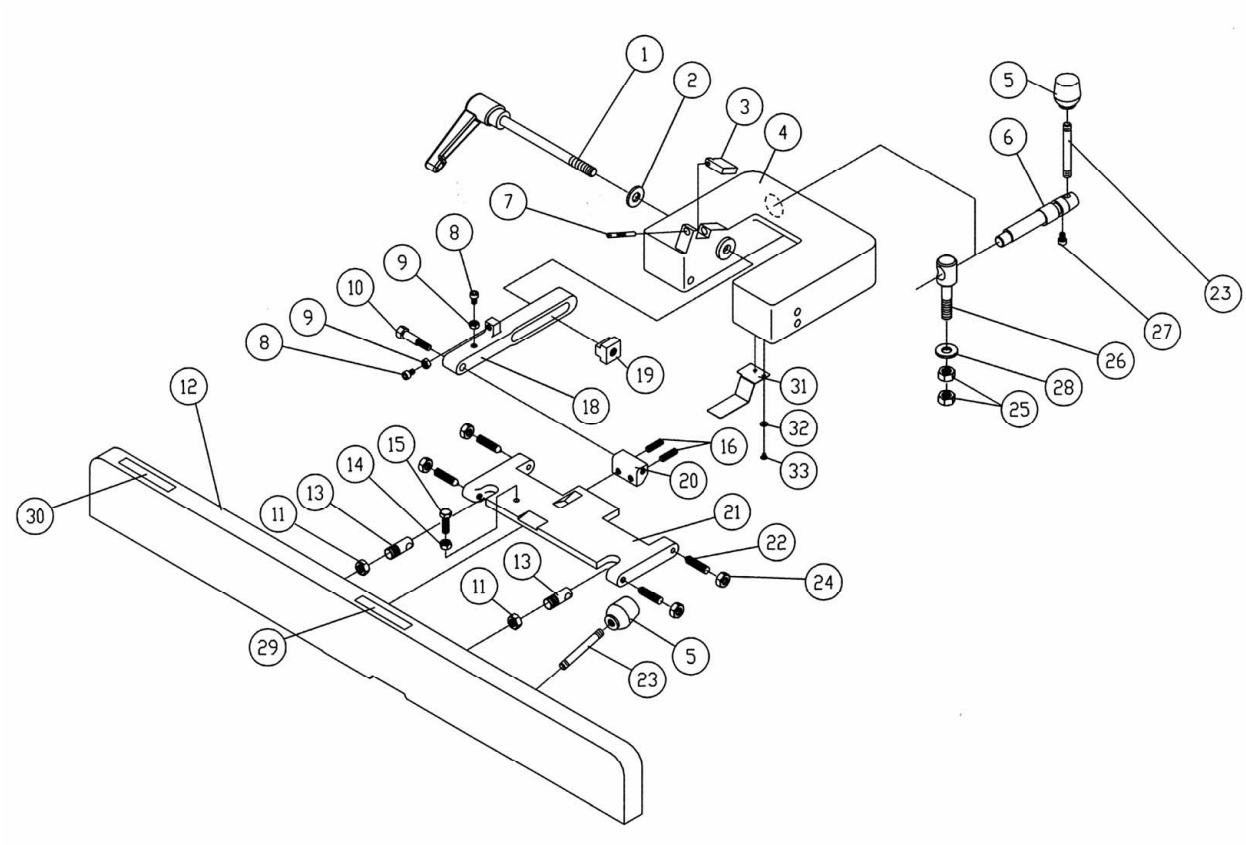
Base Assembly



Parts List: Fence Assembly

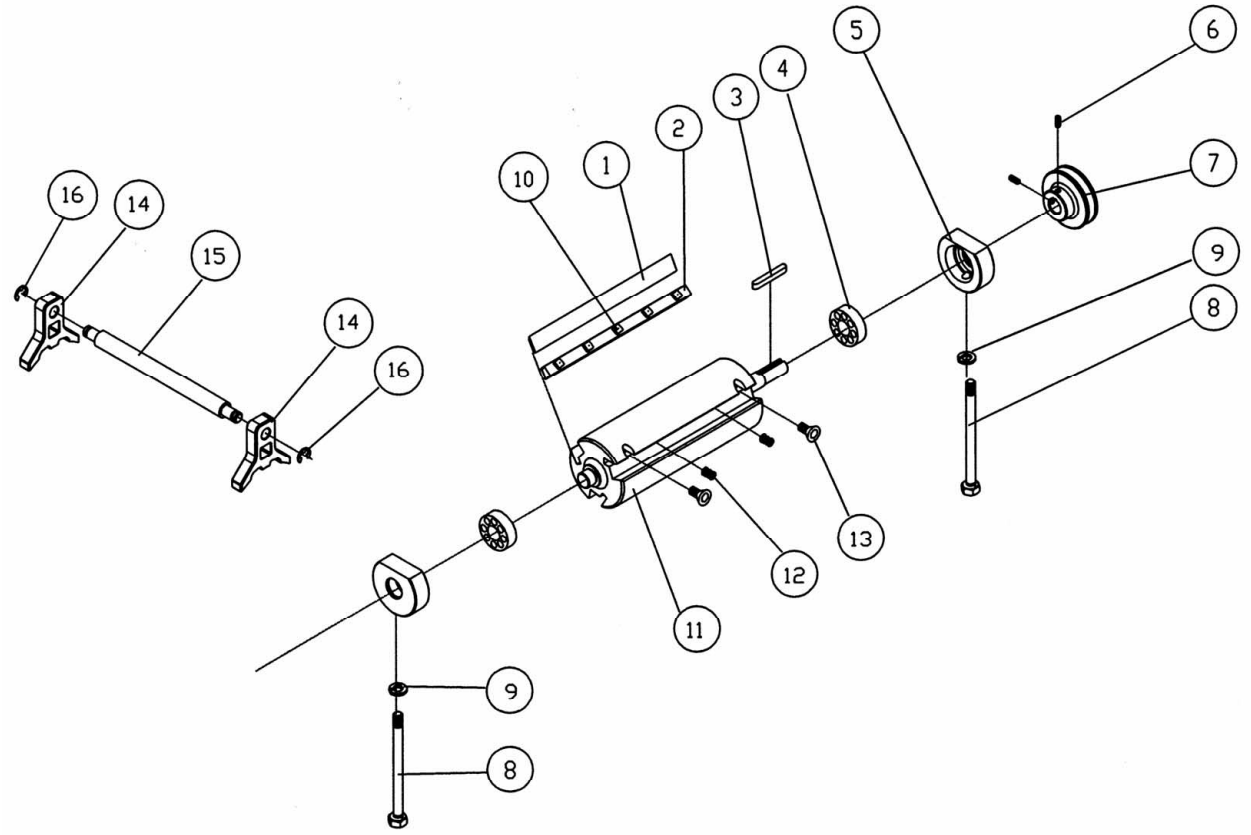
Index No.	Part No.	Description	Size	Qty
.....	60B-100	Fence Assembly (Items 1 thru 33)		1
1	6296143	Locking Bolt		1
2	6296066	Flat Washer	1/2”x1-1/8”D	1
3	6296067	Stop Block		1
4	60B-104	Fence Bracket		1
5	6285945	Knob		2
6	6296069	Locking Shaft		1
7	6296070	Pin	5mmx50mm	1
8	6296071	Cap Screw	1/4”-20x1-1/4”	2
9	6296072	Hex Nut	1/4”-20	2
10	6296073	Screw		1
11	6285940	Hex Nut	1/2”-20	2
12	60B-112	Fence Body		1
13	6296076	Bolt		2
14	6285966	Hex Nut	5/16”-18	1
15	6296077	Hex Screw	5/16”-18x1-1/4”	1
16	TS-0207061	Socket Head Cap Screw	1/4"-20x1”	2
18	6296080	Locking Link		1
19	6296081	Nut		1
20	60B-120	Fixed Block		1
21	6296082	Fence Link		1
22	6285942	Cone Point Screw		4
23	6285944	Handle Stud		2
24	6285943	Hex Nut	3/8”-16	4
25	6296083	Hex Nut	1/2”-12	2
26	6296084	Bolt		1
27	6296085	Cap Screw	1/4”-20x1/2”	1
28	TS-0680061	Flat Washer	1/2”x1-1/4”	1
29	60B-129	Caution Label (Hands Clear)		1
30	60B-130	Caution Label (Setting Knives)		1
31	60B-131	Safety Plate		1
32	TS-0680021	Flat Washer	1/4”	2
33	TS-0245021	Flat Head Screw	1/4”-20x1/2”	2

Fence Assembly



Parts List: Cutterhead Assembly

Index No.	Part No.	Description	Size	Qty
.....	60B-300	Cutterhead Assembly (Items 1 thru 5, and 10 thru 13)	.....	1
1	6296046	Knife	.....	3
2	6296153	Knife Gib	.....	3
3	6296048	Key	5x5x25	1
4	6296049	Ball Bearing	6203-2NSE	2
5	6296050	Bearing Housing	.....	2
6	6296152	Set Screw	1/4”-20x1/4”	2
7	6296051	Pulley	.....	1
8	6285853	Bolt	.....	2
9	6285852	Lock Washer	3/8”	2
10	6296154	Square Head Screw	.....	15
11	6296053	Cutterhead	.....	1
12	6296054	Spring	.....	6
13	6296055	Flat Head Screw	M5-0.8Px12	6
.....	60B-301	Knife Setting Gauge Assembly (Items 14, 15, 16)	.....	1
14	6296155	Knife Guard	.....	2
15	6296156	Knife Guard Rod	.....	1
16	6296157	E-Clip	ETW-6	2

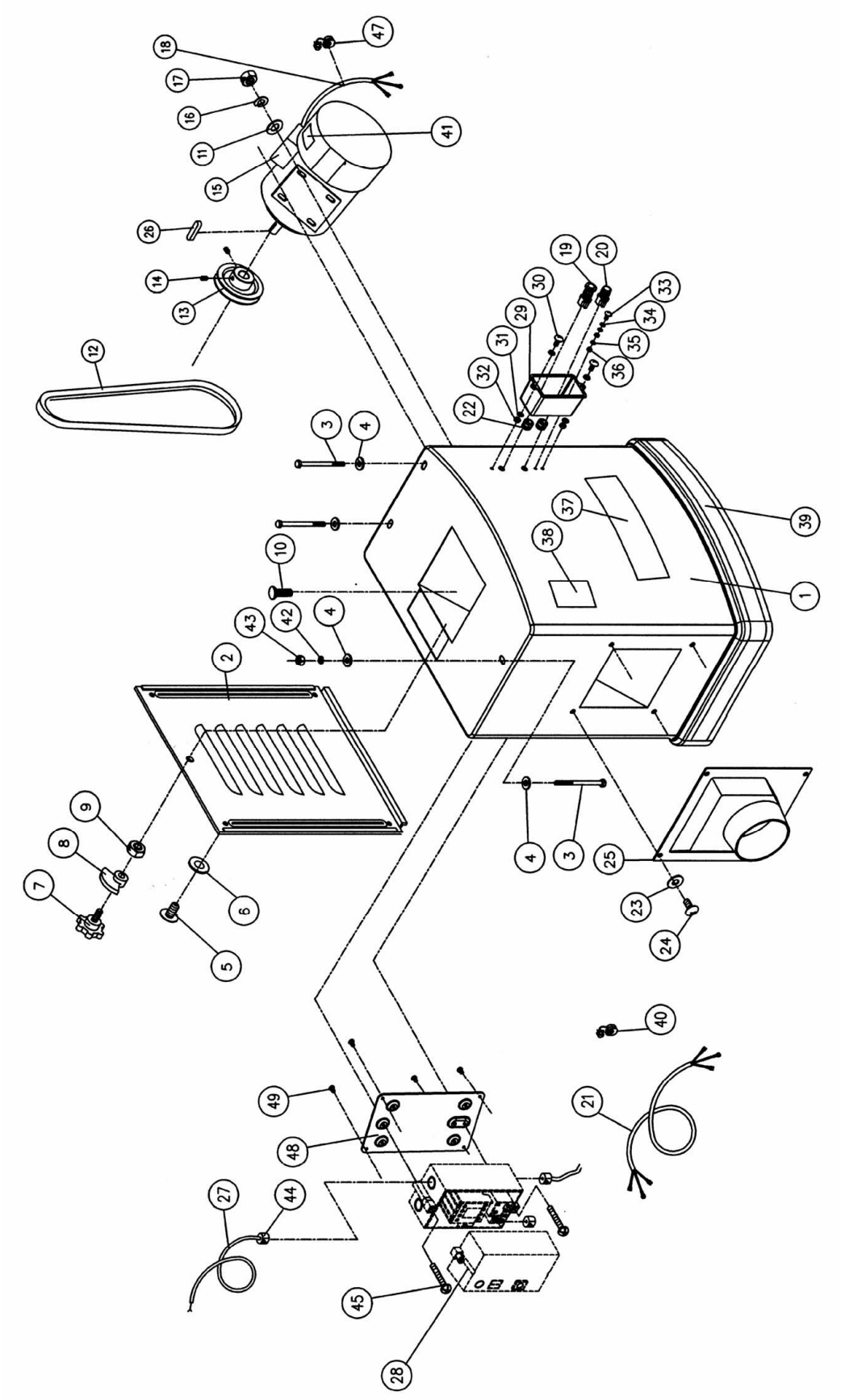


Parts List: Stand Assembly

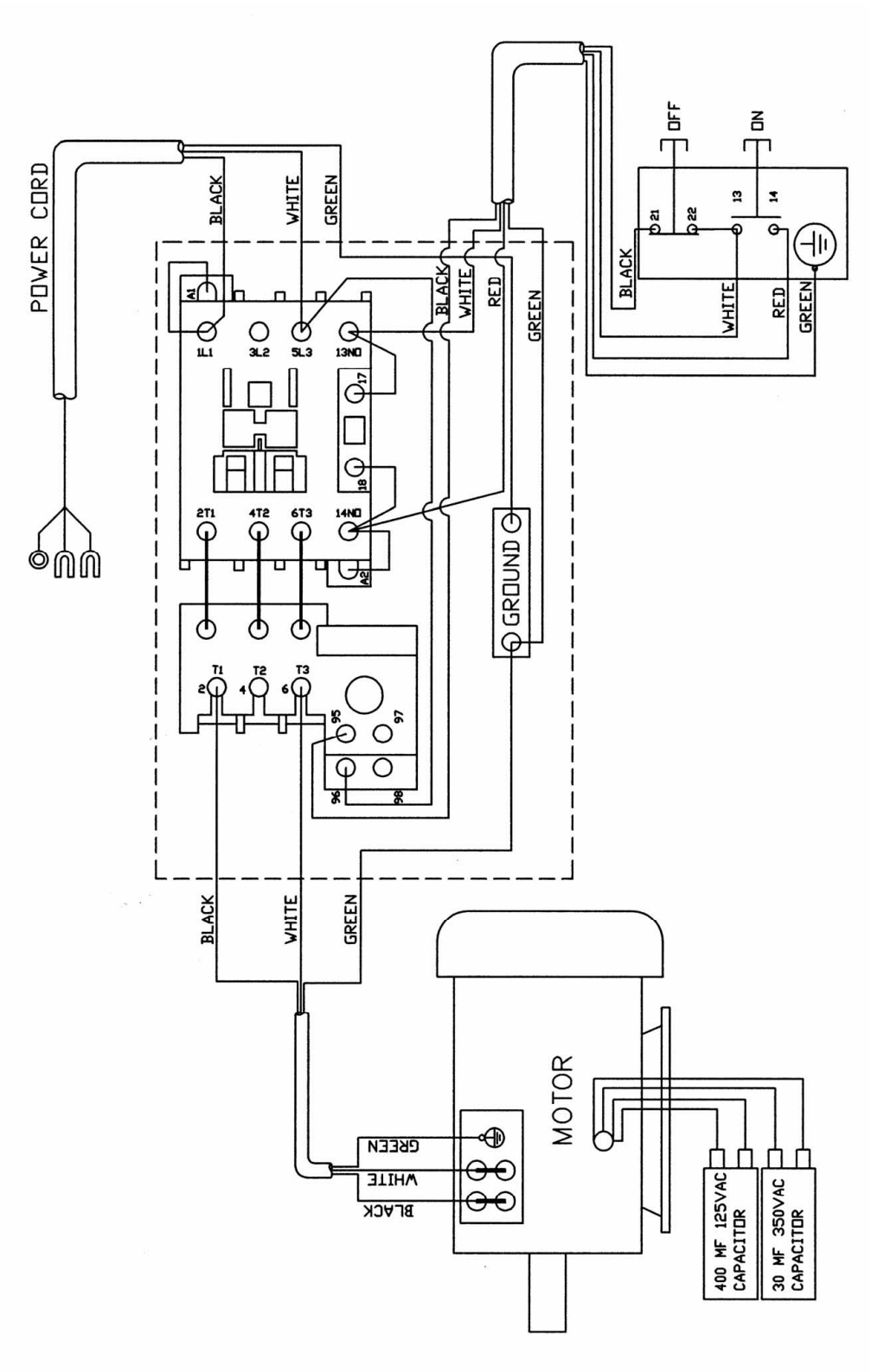
Index No.	Part No.	Description	Size	Qty
.....	2365021	Stand Assembly (Items 1 thru 47)	2HP, 1Ph, 230V	1
.....	2365023	Stand Assembly (Items 1 thru 47)	3HP, 3Ph, 230/460V	1
1	60B-401	Stand		1
2	60B-402	Door		1
3	60B-403	Lock Bolt	3/8"-16x2-3/8"	3
4	TS-1550071	Flat Washer	3/8"	6
5	TS-1534042	Pan Head Screw	M6x12	2
6	TS-1550021	Flat Washer	M6	2
7	6285975	Screw Knob		1
8	6285976	Door Lock		1
9	6285977	Hex Nut	3/8"-16	1
10	60B-410	Carriage Bolt	5/16"-18x3/4"	4
11	6285805	Flat Washer	5/16"	4
12	60B-412	V-Belt	A-44	1
13	60B-413	Motor Pulley		1
14	6296152	Set Screw	1/4"-20x1/4"	2
15	60B-415	Motor	2HP, 1Ph, 230V	1
.....	60B-415MF	Motor Fan (not shown)		1
.....	60B-415MFC	Motor Fan Cover (not shown)		1
.....	60B-415CS	Centrifugal Switch (not shown)		1
.....	60B-415MDC	Motor Dustproof Cover (not shown)		1
.....	60B-415CC	Capacitor Cover (not shown)		2
.....	60B-415SC	Starting Capacitor (not shown)	400MFD, 125VAC	1
.....	60B-415RC	Running Capacitor (not shown)	30uf, 350VAC	1
.....	60B-415A	Motor	3HP, 3Ph, 230/460V	1
16	6285988	Lock Washer	5/16"	4
17	6285966	Hex Nut	5/16"-18	1
18	60B-418	Motor Cord	1Ph	1
.....	60B-418A	Motor Cord	3Ph	1
19	60B-419	Start Switch		1
20	60B-420	Stop Switch		1
21	60B-421	Power Cord	1PH	1
.....	60B-421A	Power Cord	3PH	1
22	60B-422	Strain Relief		1
23	6285909	Flat Washer	1/4"	4
24	6285910	Pan Head Screw	1/4"-20x1/2"	4
25	60B-425	Dust Chute		1
26	6285978	Key	5x5xx30	1
27	60B-427	Switch Cord		1
28	60B-428	Magnetic Switch	1PH	1
.....	60B-428CS	Contactors Switch		1
.....	60B-428OR	Overload Relays		1
.....	60B-428AA	Magnetic Switch	3PH	1
.....	60B-428ACSA	Contactors Switch		1
.....	60B-428AOR	Overload Relays		1
.....	60B-428AT	Transformer		1
.....	60B-428AF	Fuse		1
29	60B-429	Switch Box		1
30	TS-1533052	Pan Head Screw	M5-0.8Px16	2
31	TS-1550031	Flat Washer	5.3x12x1T	2
32	TS-1540031	Hex Nut	M5x0.8P	2
33	TS-081C062	Pan Head Screw	#10-24x1"	1
34	6860800	Flat Washer	#10	1
35	TS-073203	Star Washer		2
36	6510001	Hex Nut	#10-24	2
37	3312341	Powermatic Logo		1
38	6296150	Warning Label		1

39	6823013	Stripe		8 ft.
40	60B-440	Strain Relief		1
	60B-440A	Strain Relief		1
41	60B-441	Motor Label		1
42	6285852	Lock Washer	3/8”	3
43	6285943	Hex Nut	3/8”-16	3
44	60B-444	Strain Relief		3
	60B-444A	Strain Relief		3
45	TS-081C022	Pan Head Screw	#10-24x3/8”	2
47	60B-447	Strain Relief		1
	60B-447A	Strain Relief		1
48	60B-448	Switch Plate		1
49	TS-1533042	Phillips Pan Head Machine Screw	M5x0.8x12	1

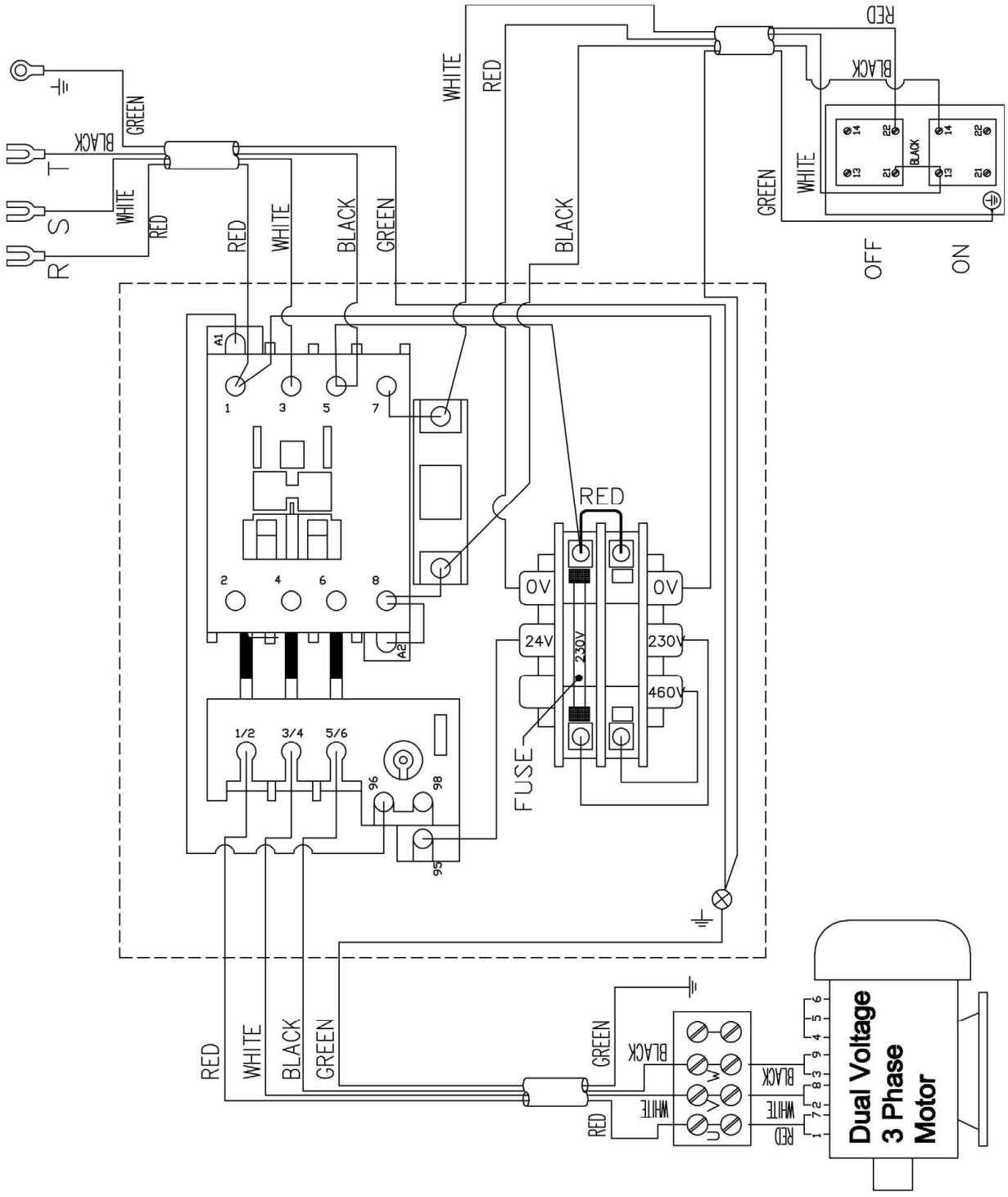
Stand Assembly



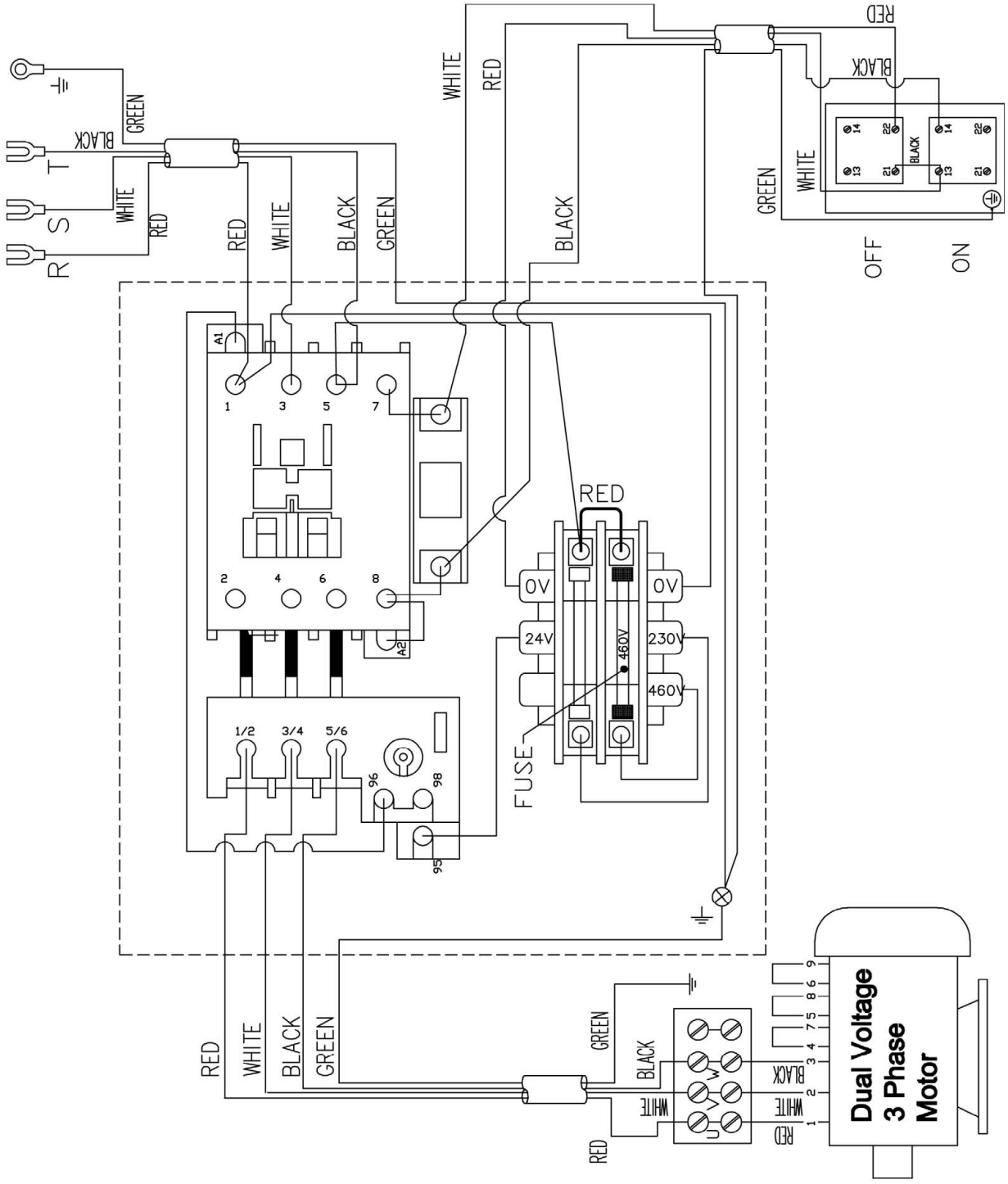
Electrical Connections – *230 Volt, Single Phase*



Electrical Connections – *230 Volt, 3 Phase*



Electrical Connections – *460 Volt, Three Phase*



Preventive Maintenance

Checklist for Model 60B Jointer

[ ] Work area around machine marked off clearly.

[ ] Non-skid floor strips in area where operator normally stands.

[ ] Kickback path not aimed at other work areas, aisles or doorways.

[ ] Various types of push pads and blocks readily available to operator.

[ ] Inspect entire machine for loose bolts, nuts, screws. Tighten and replace as necessary.

[ ] Cutter guard in place and working properly.

[ ] Clean table area, removing sawdust and chips with a soft bristle brush or compressed air. Remove gum and pitch with oven cleaner.

[ ] Lubricate appropriate places with a good grade non-hardening grease.

[ ] Clean table and fence surface. If rusted, use paste mixture of household ammonia, a good commercial detergent and 000 steel wool. Wash surface down with hot, soapy water, rinse and dry thoroughly. Coat surface with talcum powder, rubbing briskly into surface with a clean blackboard eraser; or apply a light coat of paste wax.

[ ] Check knife condition; should be sharp and free of nicks or grooves. Knives set at proper height using supplied gauge, and locked securely in cutterhead.

[ ] Gibs are adjusted for light drag on both outfeed and infeed table movements.

[ ] Outfeed table in line with top of arc of cutterhead. All blades arc within .002".

[ ] Check belt condition. Replace as needed. Dress with paraffin. Check belt tension.

[ ] Check motor for loose wiring and sawdust congestion, pulleys tight and in line.

[ ] Check bearings. Replace any bad or suspect bearings immediately.

[ ] Fence square with table, clamped tightly to fence support.

POWERMATIC®

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